

Work Order ID 110136

December-17-13 9:15:54 AM

110136

Page 1

Item ID: D3234-1 **B110136** Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: **D3234-1** Stop ***NS2***
Item Name: Doubler
Start Date: 12/17/13 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 12/17/13 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 13-12-19 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3234	C								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
2024.080	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

6 0 Jan 14-02-12

6 0 Jan 14-02-12

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Item ID: D3234-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 12/17/13 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 12/17/13 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 DAS 27 3-89 4/2/12				6			
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				6	16,142,13		
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 DAS 27 3-89 4/2/13				6			

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Item ID: D3234-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 12/17/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: ST 177.

0.00

150

Packaging

Memo

0.00

Packaging

OK 14-2-13

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

14-02-1414-02-13

Picklist Print

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Work Order ID: 110136

Parent Item: D3234-1

Parent Item Name: Doubler

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 08-08-14 JLM Verified By:EC
IPP Rev:B 08-12-18 as per ECN08-582 DD verified by:EC IPP REV:C 11.11.24 AS PER
ECN11-674 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080 2024-T3 .080 sheet		Purchased	No			100	sf	138.5690	0.58	3.6631578	4.0	Jm14-02-12	
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT022		138.569					
						M127668		138.569		127668			

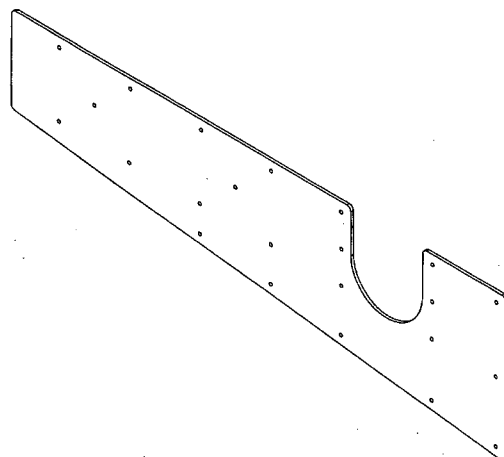
DART AEROSPACE LTD		Work Order: 110136
Description: Doubler		Part Number: D3234-1
Inspection Dwg: D3234 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

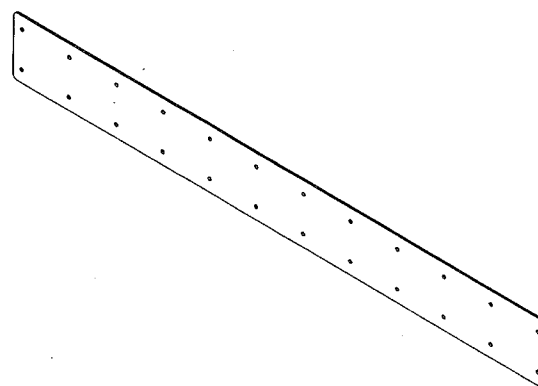
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.099"	—		✓	Jkmo1
0.285	+/-0.010	0.286"	—		✓	
1.295	+/-0.010	1.296"	—		✓	
2.305	+/-0.010	2.307"	—		✓	
2.700	+/-0.010	2.701"	—		✓	
4.505	+/-0.010	4.509"	—		✓	
1.33	+/-0.030	1.336"	—		✓	
1.523	+/-0.010	1.524"	—		✓	
2.641	+/-0.010	2.643"	—		✓	
3.758	+/-0.010	3.754"	—		✓	
5.993	+/-0.010	5.998"	—		✓	
7.111	+/-0.010	7.114"	—		✓	
8.228	+/-0.010	8.228"	—		T	Jkmo6
10.463	+/-0.010	10.463"	—		T	
10.77	+/-0.030	10.77"	—		T	
2.25	+/-0.030	2.257"	—		✓	
13.333	+/-0.010	13.333"	—		T	
15.366	+/-0.010	15.366"	—		T	
15.665	+/-0.010	15.665"	—		T	
0.080	+/-0.010	0.080"	—		✓	

Measured by: Jm	Audited by: DAS	Preliminary Approval:
Date: 14-02-12	Date: 14-2-12	Date:

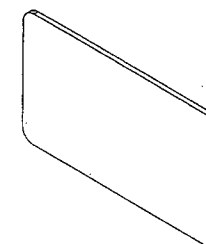
Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	
B	09.05.04	Dimensions update per Rev B	KJ/DD	
C	12.02.01	Dimensions update per Rev C	KJ	



D3234-1 DOUBLER



D3234-3 DOUBLER



D3234-5 SPACER

110136 MJS
13-12-19

NOTES:

1) MATERIAL: -1: 2024-T3 ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.080

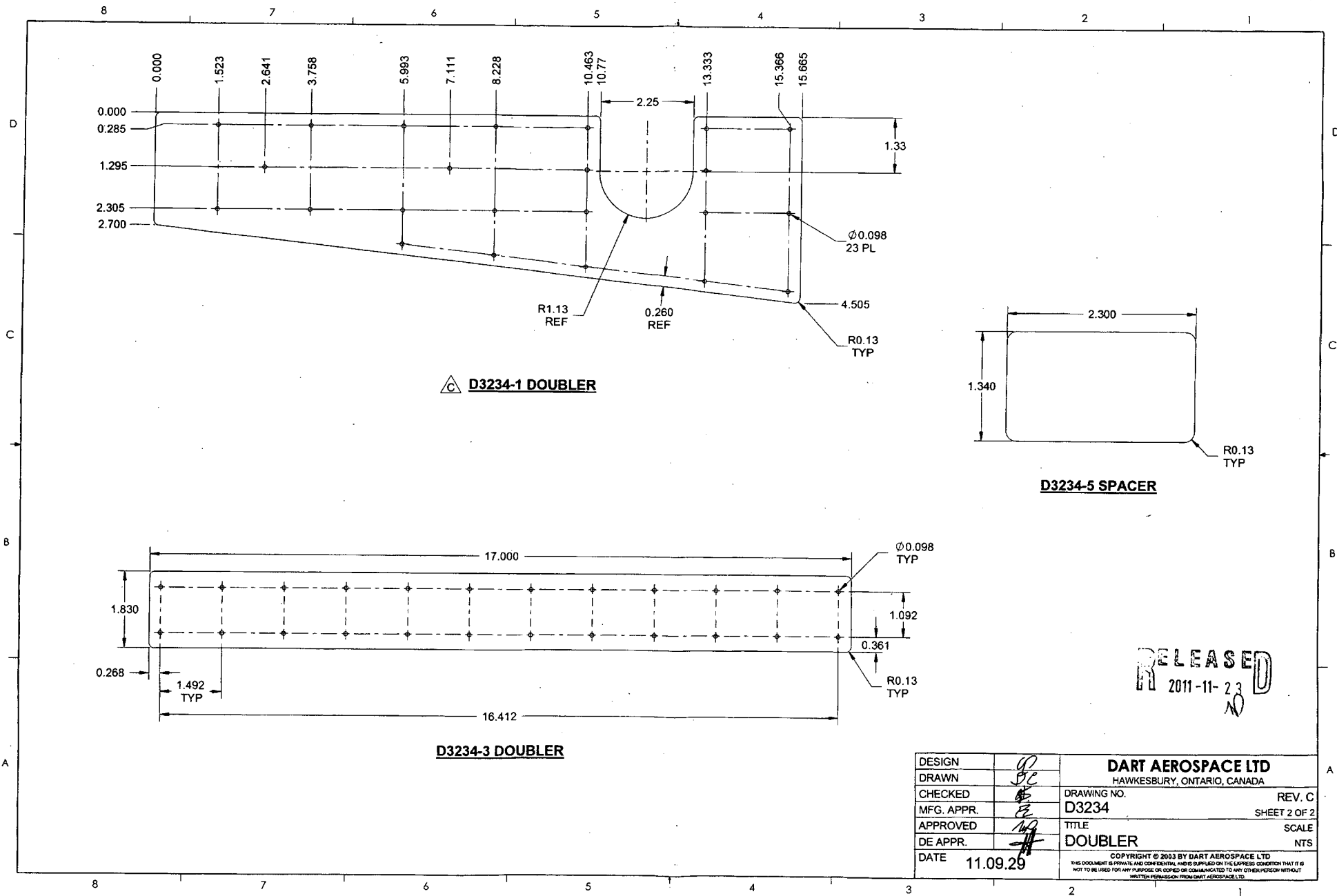
-3: 2024-T3 ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.050

-5: 5052-H32 ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF DART SPEC M5052H32S.050

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
7) WEIGHT: -1: 0.41 lbs
-3: 0.15 lbs
-5: 0.01 lbs

RELEASED
2011-11-33

C	RE-DESIGNED D3234-1 TO FIT D3025-1 REV. B. ZONE C3-2, 4.505 WAS 5.347, ZONE D8-2, 2.700 WAS 2.841. REASON: REF PAR 11-118.	PC	11.09.29
B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. PARTS FULLY DIMENSIONED. NO PHYSICAL CHANGES MADE TO PARTS. REASON: REF PAR 08-029.	AJS	08.11.24
A	NEW ISSUE	CP	03.11.19
REV.	DESCRIPTION	BY	DATE
DESIGN	PC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PC		
CHECKED	PC	DRAWING NO.	REV. C
MFG. APPR.	PC	D3234	SHEET 1 OF 2
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	DOUBLER	NTS
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RELEASED
2011-11-23
NO

DESIGN	D	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	E	DRAWING NO.	REV. C
MFG. APPR.	E	D3234	SHEET 2 OF 2
APPROVED	149	TITLE	SCALE
DE APPR.	H	DOUBLER	NTS
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